

Date: Monday, 10/23/2006 12:03:48 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B FWD X-TUBE
Job Number	: 29102	Part Number	: D206667101
Estimate Number	: 12346	Drawing Number	: D206-667-141REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 10/23/2006 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: // Type : LANDING GEAR	Due Date	: 11/20/2006 Qty: 1 Um: Each
Previous Run	: 29101		
Written By	: <u>                    </u>		
Checked & Approved By	: <u>                    </u>		
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

## Additional Product

*Labels already gone*

Job Number:



Seq. #: Machine Or Operation:

1.0 DC



Comment: DOCUMENT CONTROL  
 Photocopy bluefile and create lat

2.0 D6001105



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube 25601

Check OD = 2.250"; ID = 1.874"

3.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Deburr &amp; inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206B FWD X-TUBE

Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC-LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

3-Polish entire outside surface of crosstube

*250 06-12-17*

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

Inside of Cuff(Donot engrave on outside of tube)

*BC 06.10.26*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*BC 06.10.26*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*250 06/10/27*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*DP/05*

*6-12-7*

*(PK)*

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT\_\_\_\_\_

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

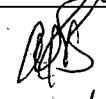
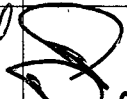
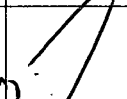
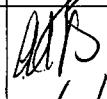
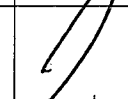


Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/08	9.0	Tube is scrap, all claims me. no good, and very un-even.	 07/09/19	Scrap. Destroy. No good in eng. lab.	 29-20 07-09-19	 07-09-19	 07/09/19	 07-09-19

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:03:48 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	QC6	DIMENSIONAL CHECK
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Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

19.0	QC14	Inspect Spray Paint
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Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

2	D2856-400(Cut to 6.94")	Abrasion Strip	
---	-------------------------	----------------	--

21.0	D2873043	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

2	D2873-043	Nut Plate	
---	-----------	-----------	--

22.0	D2873045	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

2	D2873-045	Nut Plate	
---	-----------	-----------	--

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

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Drawing Name: 206B FWD X-TUBE

Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support \_\_\_\_\_

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet \_\_\_\_\_

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp \_\_\_\_\_

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

30.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
Batch: \_\_\_\_\_

31.0	AN57A	Bolt
------	-------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
10 AN5-7A Bolt \_\_\_\_\_

32.0	AN530A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
4 AN5-30A Bolt \_\_\_\_\_

33.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
18 AN960JD516 Washer \_\_\_\_\_

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D206-667-101  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:03:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29102

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07-06-28*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

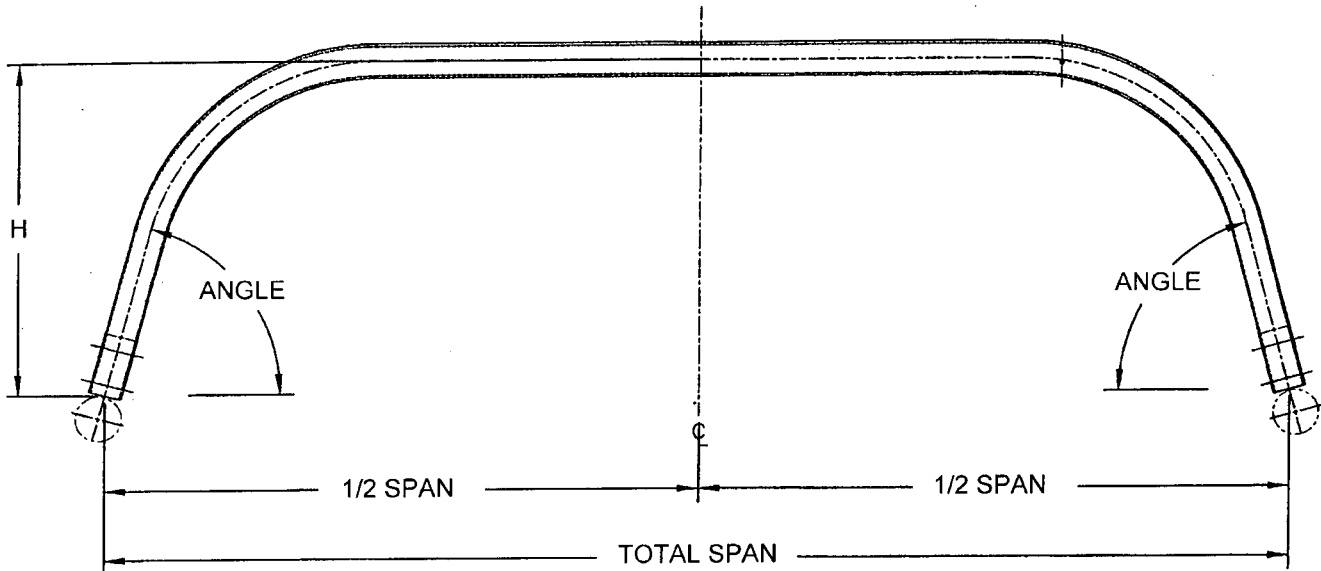
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Crosstube Bend Dimension Sheet



PART NUMBER: \_\_\_\_\_

BATCH NUMBER: 29102

DRAWING: \_\_\_\_\_ REVISION: \_\_\_\_\_

H: \_\_\_\_\_

1/2 SPAN: \_\_\_\_\_

TOTAL SPAN: \_\_\_\_\_

ANGLE: \_\_\_\_\_

QC 15: \_\_\_\_\_

DATE: \_\_\_\_\_

QTY: \_\_\_\_\_





**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26**UNDER REVIEW**  
05.08.10 PH  
re-draw detail F  
05.10.23  
PH

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

**GENERAL NOTES:**

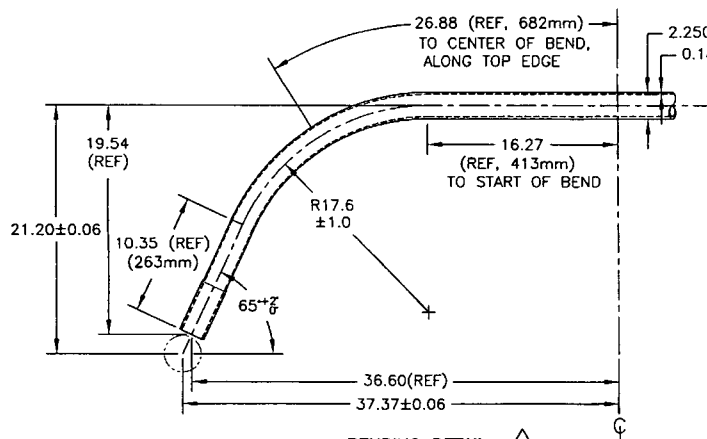
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. 29102

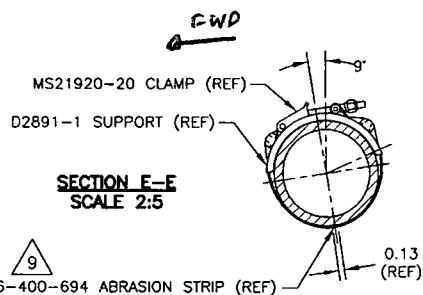
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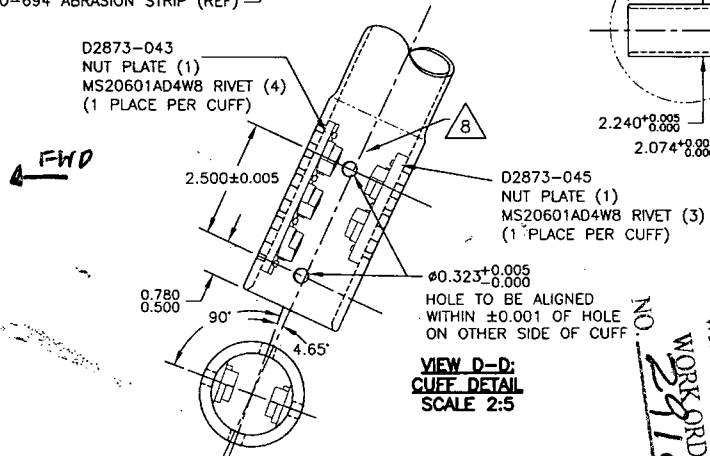




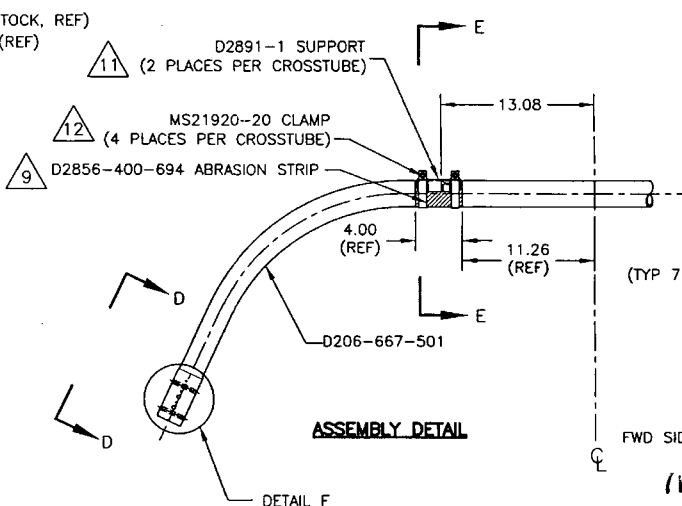
**BENDING DETAIL 6**



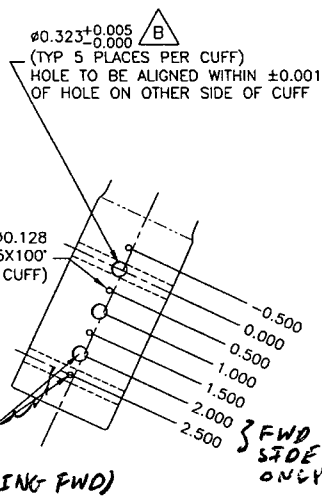
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**VIEW D-D: CUFF DETAIL SCALE 2:5**

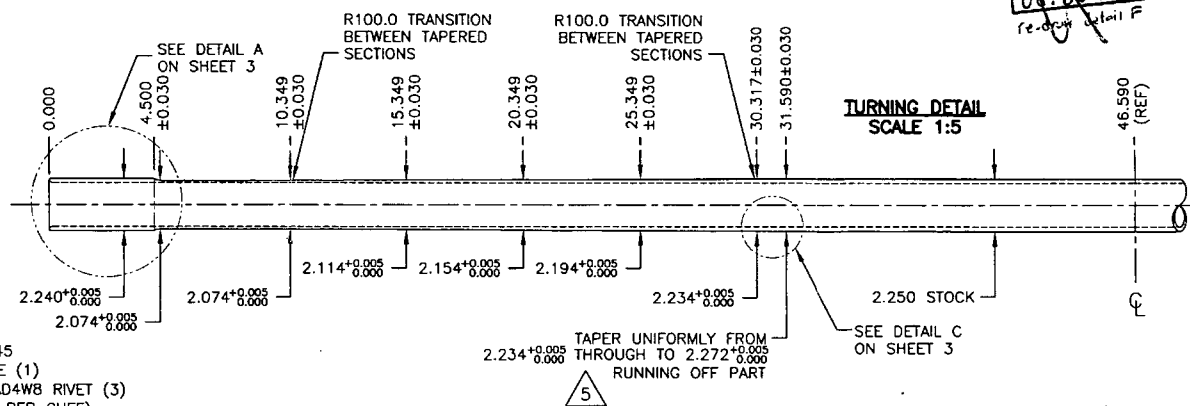


**ASSEMBLY DETAIL**



**DETAIL F SCALE 2:5**

**UNDER REVIEW**  
05.08.10 PH  
re-order detail F



**TURNING DETAIL SCALE 1:5**

NO. 29102  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING

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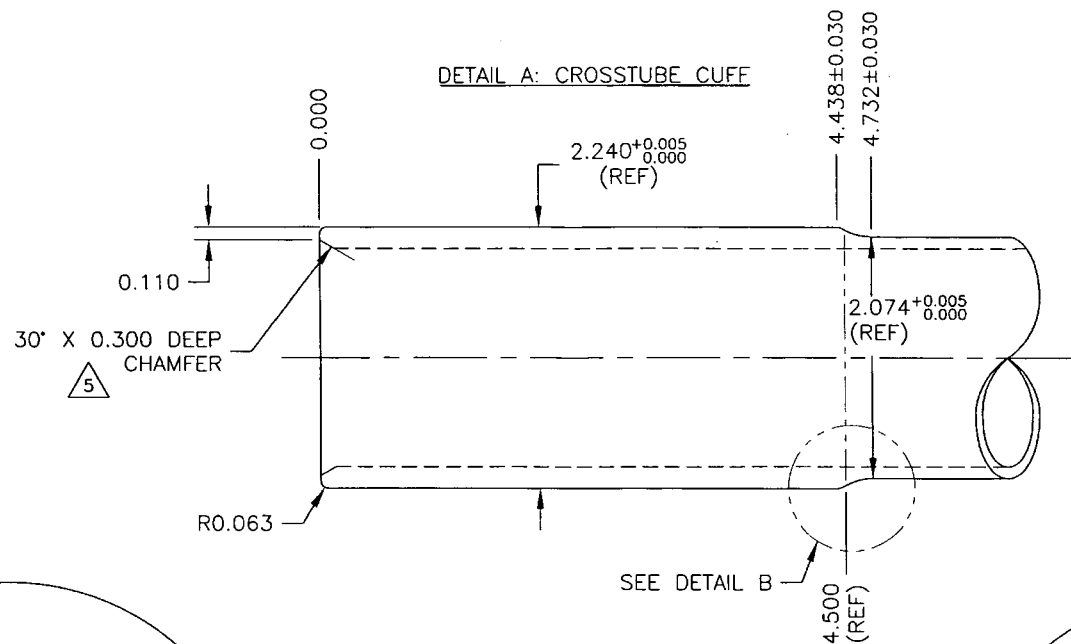
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CHECKED	DS	APPROVED	DS	DRAWING NO.	REV. B
DATE	05.07.26			D206-667-141	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH FWD)	1:10

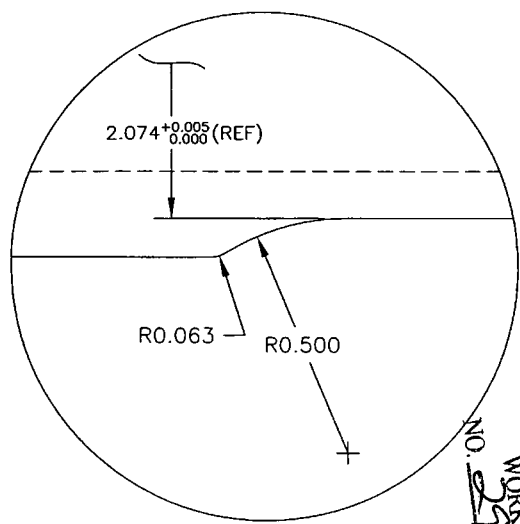
RELEASED  
05.07.26



# DETAIL A: CROSSTUBE CUFF

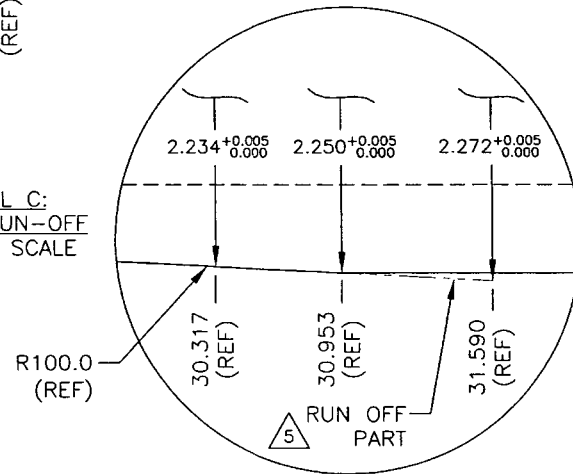


**UNDER REVIEW**  
 06.08.10 PH  
 re-draw detail F  
 06.10.23  
 PH  
 05.07.26



DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1

DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE



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 WORK ORDER  
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #DS	APPROVED #US	DRAWING NO. D206-667-141	REV. B SHEET 3 OF 3
		DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE 1:1



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29102
<b>Description:</b> Crosstube Assembly (206B High Fwd)	<b>Part Number:</b> D206-667-141
<b>Inspection Dwg:</b> D206-667-141 <b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.119	✓			
	2.154	+0.005/-0.000	2.159	✓			
	2.194	+0.005/-0.000	2.197	✓			
	2.234	+0.005/-0.000	2.237	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
SIDE B	2.240	+0.005/-0.000	2.240	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.118	✓			
	2.154	+0.005/-0.000	2.158	✓			
	2.194	+0.005/-0.000	2.197	✓			
	2.234	+0.005/-0.000	2.238	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
	93.18	+/-0.020	93.18	✓			

<b>Measured by:</b> BG	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06.10.26	<b>Date:</b> 06/10/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	

